

Date: Friday, 10/5/2007 10:58:54 AM  
 \*User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 35037	
Estimate Number : 10584	
P.O. Number : <i>N/A</i>	Part Number : D1048
This Issue : 10/5/2007 S.O. No. : <i>N/A</i>	Drawing Number : D1048 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i>	Drawing Revision : A
Previous Run : 30373	Material : <i>N/A</i>
Written By : _____	Due Date : 10/12/2007
Checked & Approved By : <i>07.10.05</i>	Qty: <i>100</i> Um: Each
Comment : Est: B 02.02.22 Re-format NG Est Rev: C Now on Waterjet 06-12-06 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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*1.3224*

Comment: Qty.: 0.0116 sf(s)/Unit Total : 0.5775 sf(s)  
 304/316 .063 Sheet *B 07-10-16*  
 Batch: *105130*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D1048  
 Dwg Rev: *A*  
 Prog Rev: *A*

*B 07-10-16*

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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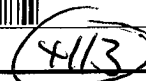
*AB 07-10-16*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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*cauto*

Comment: SECOND CHECK

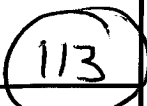
*Er 07/10/16*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.


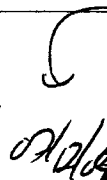

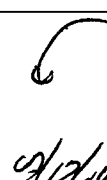
*SAD 07/10/22*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/12/06

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-12-03	6.0	Scrap one part, testing was unclear. Part was formed wrong R.C. Hemman error	 08/10/02	Scrap & destroy	SAN 07-12-03	 07/12/04	 08/10/02	 07/12/04

NOTE: Date & initial all entries

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Drawing Name: CLAMP

Job Number: 35037

Part Number: D1048

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



NO  
Mains Page

Comment: NC BRAKE

1-Form as per dwg D2010 using DT8053

SAD 07-12-07

112

7.0

QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

2 112/4 x112

8.0

POWDER COATING

POWDER COATING



M100 700

112X

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-L 07/12/05

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



112

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 07-12-05

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 2

11/2/06 SD 112X

11.0

QC21

FINAL INSPECTION/W/O RELEASE



112

Comment: FINAL INSPECTION/W/O RELEASE

07/12/06

Job Completion



U 07.12.06

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

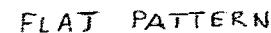
**NOTE:** Date & initial all entries

97/09/02 BL


## 1) MATERIAL

T304#2B .062 THICK

3) BREAK ALL SHARP EDGES 0.010 TO 0.020



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01.12.05 ADD FLAT PATTERN	A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
	RF	DRAWN			BASIC CODE	ON DASH NO. W/HEAD WEAR SIDE F=HEAD FAR SIDE	CONTRACT NO.		 <b>DART AERO ACCESSORIES INC.</b> VANCOUVER CANADA		
		APPROVED			D=HOLE DIGIT NO OF SHEETS C=COUNTERSINK	LENGTH DASH NO. W=SPOTWELD	DRAWN BRADLEY	DATE 5/1/97			
			REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL LIMITS		BASIC CODES		DESIGN BRADLEY		TITLE CLAMP		
		DESCRIPTION OF CHANGE	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125/1 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - 5 - 7742 5. HOLES PER AND 10387		1. TOLERANCES — .XX .030 .XX .010 2. ANGLES 2° 10° 3. PARALLELISM 1.0075 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005		BL=MS20470AD BE=MS20426AD		STRESS CHECKED CLIENT	CODE DWG NO D1048 SCALE 1:1 SHT 1 OF 1	REV A
REPORT ALL DISCREPANCIES — DO NOT SCALE											

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WORK ORDER  
NO. 25037

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